

Date: Thursday, 5/4/2006 11:09:47 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 26928D		Part Number	: D30657		
Estimate Number	: 10380		Drawing Number	: D3065 REV. A2		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/4/2006	S.O. No. : N/A	Drawing Revision	: A2		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/15/2006		
Previous Run	: 26452D		Qty:	60	Um:	Each
Written By	: See <u>KJ</u> comment below					
Checked & Approved By	: <u>KJ</u> 06.05.05					
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		 Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M19295</u> <u>M 06 05 16</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D <u>3065</u> <u>jm</u> Dwg Rev: <u>A2</u> Prog Rev: <u>A2</u> <u>M 06 05 16</u> <u>6063</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>M 06 05 16</u> <u>6063</u>
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK <u>Locos. 17</u> <u>63</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>HM 06/05/17</u> <u>63</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per Dwg D30657

SB 06/05/25

63

7.0	QC5	INSPECT WORK TO CURRENT STEP
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63

Comment: INSPECT WORK TO CURRENT STEP

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/29

63

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT CHEMICAL CONVERSION COAT

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PATRVAL

06/05/30 63

11.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/31

63

Job Completion



u 06/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	26928D
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>W. W.</u>	Audited by: <u>Z</u>	Prototype Approval: N/A
Date: <u>06-05-16</u>	Date: <u>06-05-17</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	



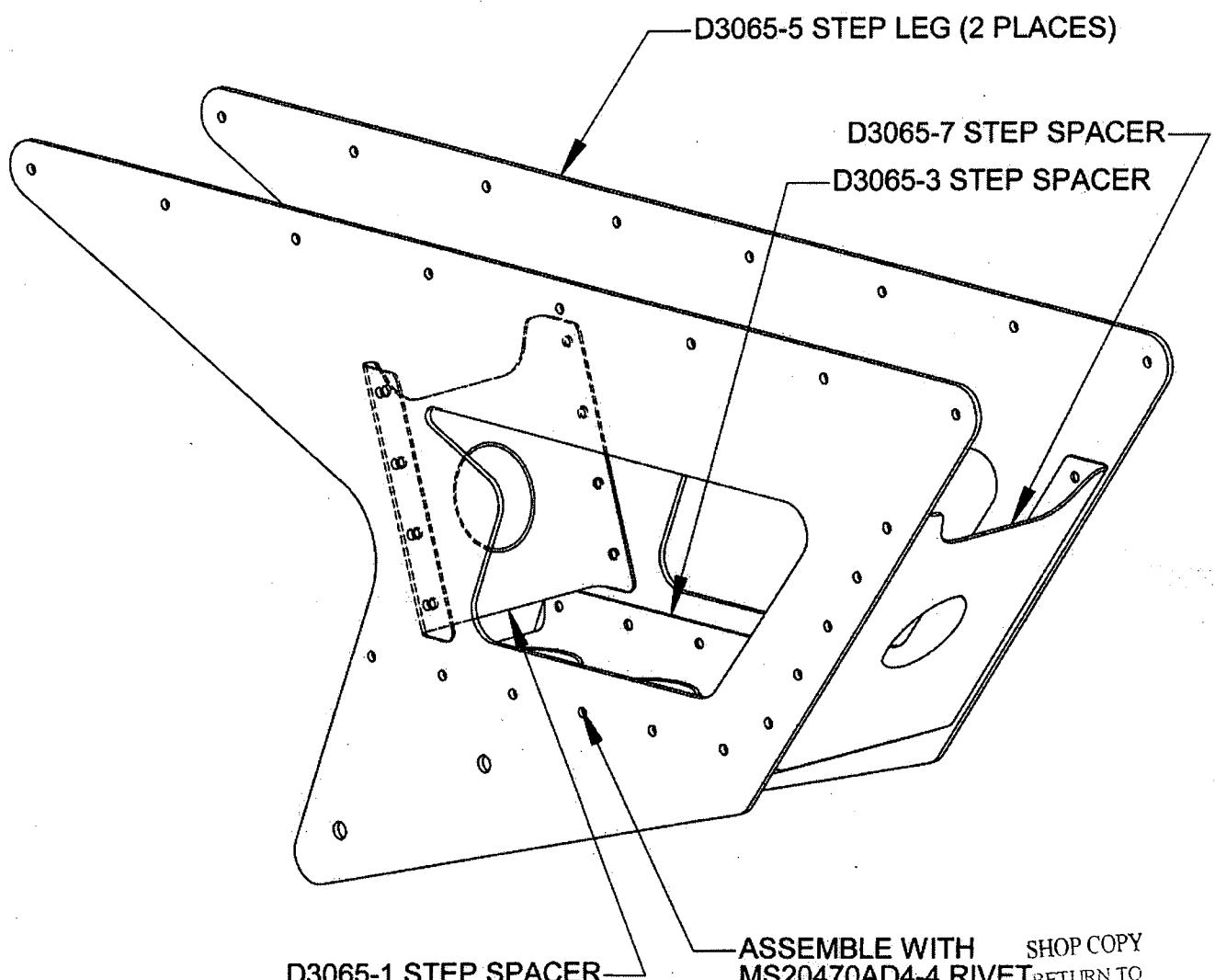
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DATE	02.09.11	TITLE	SCALE

STEP LEG ASSEMBLY

1:2

RELEASED
02.09.20 *HP*

A	02.09.11	NEW ISSUE
A1	03.02.13 <i>HP</i>	ADD SLOTS TO D3065-5
A2	03.02.27 <i>HP</i>	0.551 WAS 0.410



D3065-041 STEP LEG ASSEMBLY

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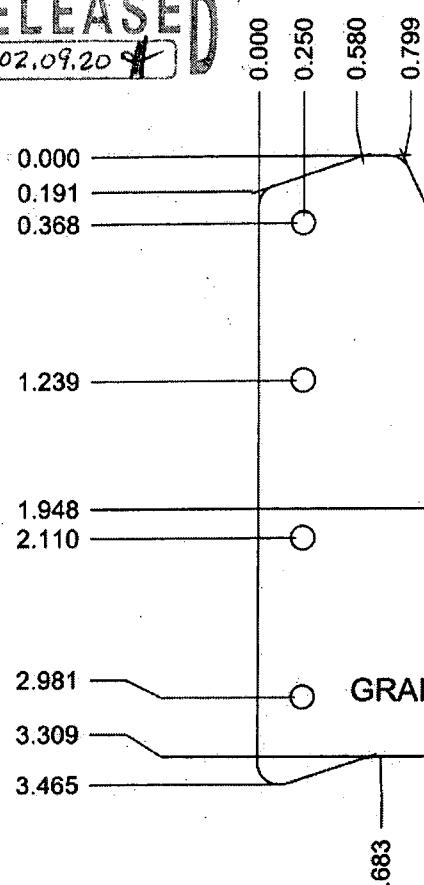
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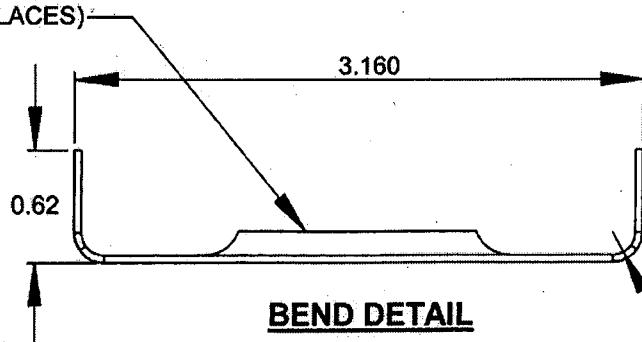
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RELEASED
02.09.20



FLAT PATTERN

FLANGE AFTER BENDING
TOWARDS SIDE SHOWN
USING DT8174
(2 PLACES)



BEND DETAIL

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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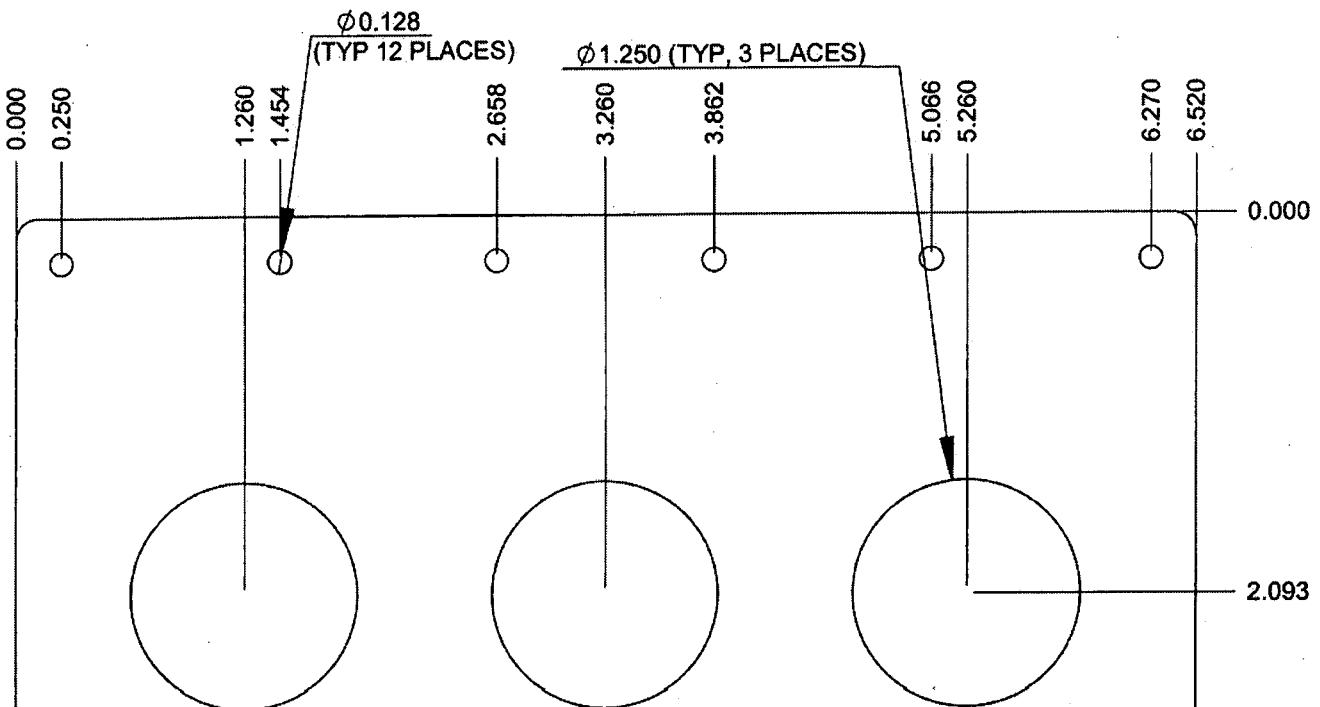
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DART



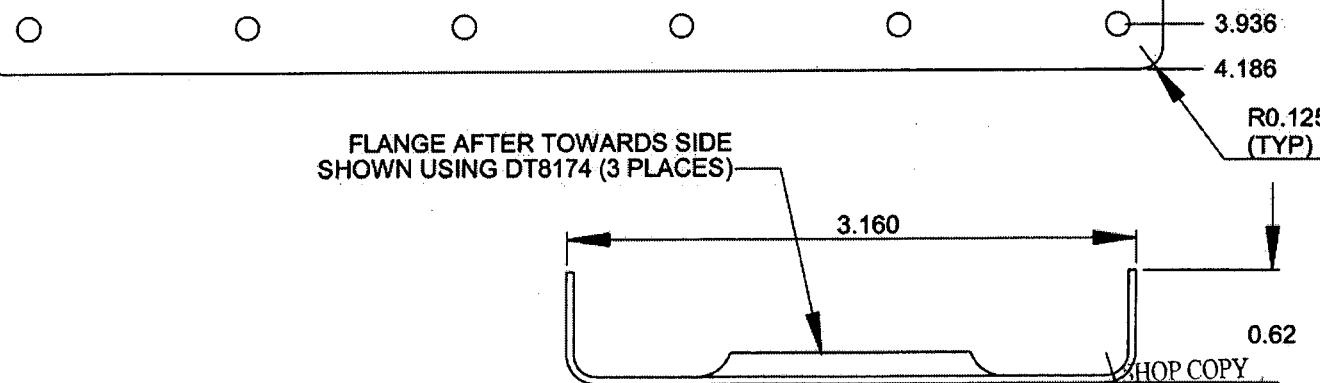
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DATE	02.09.11	TITLE STEP LEG ASSEMBLY

REV. A
SHEET 3 OF 5
SCALE
1:1



FLAT PATTERN

GRAIN DIRECTION



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

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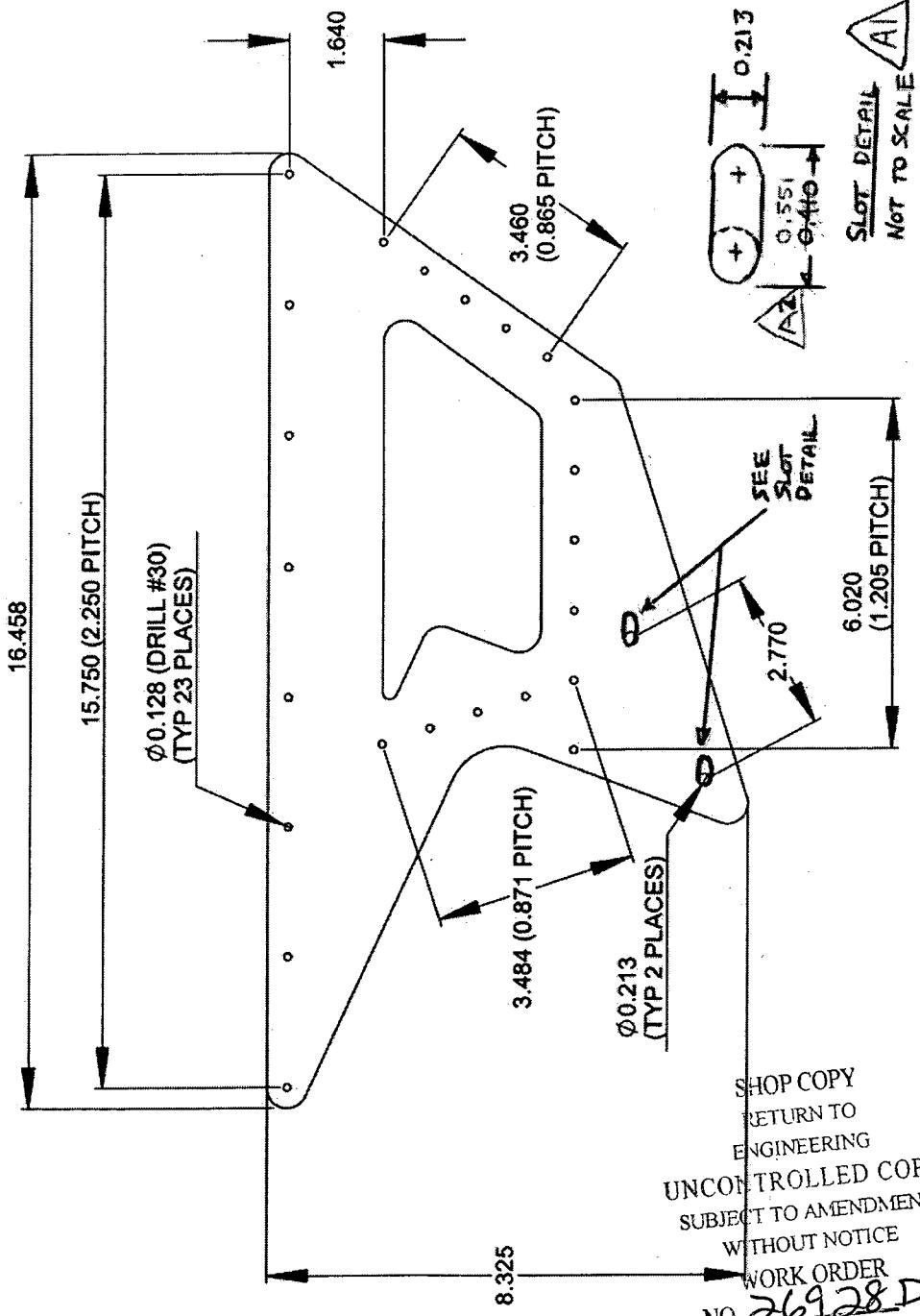
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DATE	02.09.11	TITLE STEP LEG ASSEMBLY	SCALE 1:3

RELEASED
02.09.20



D3065-5 STEP LEG
 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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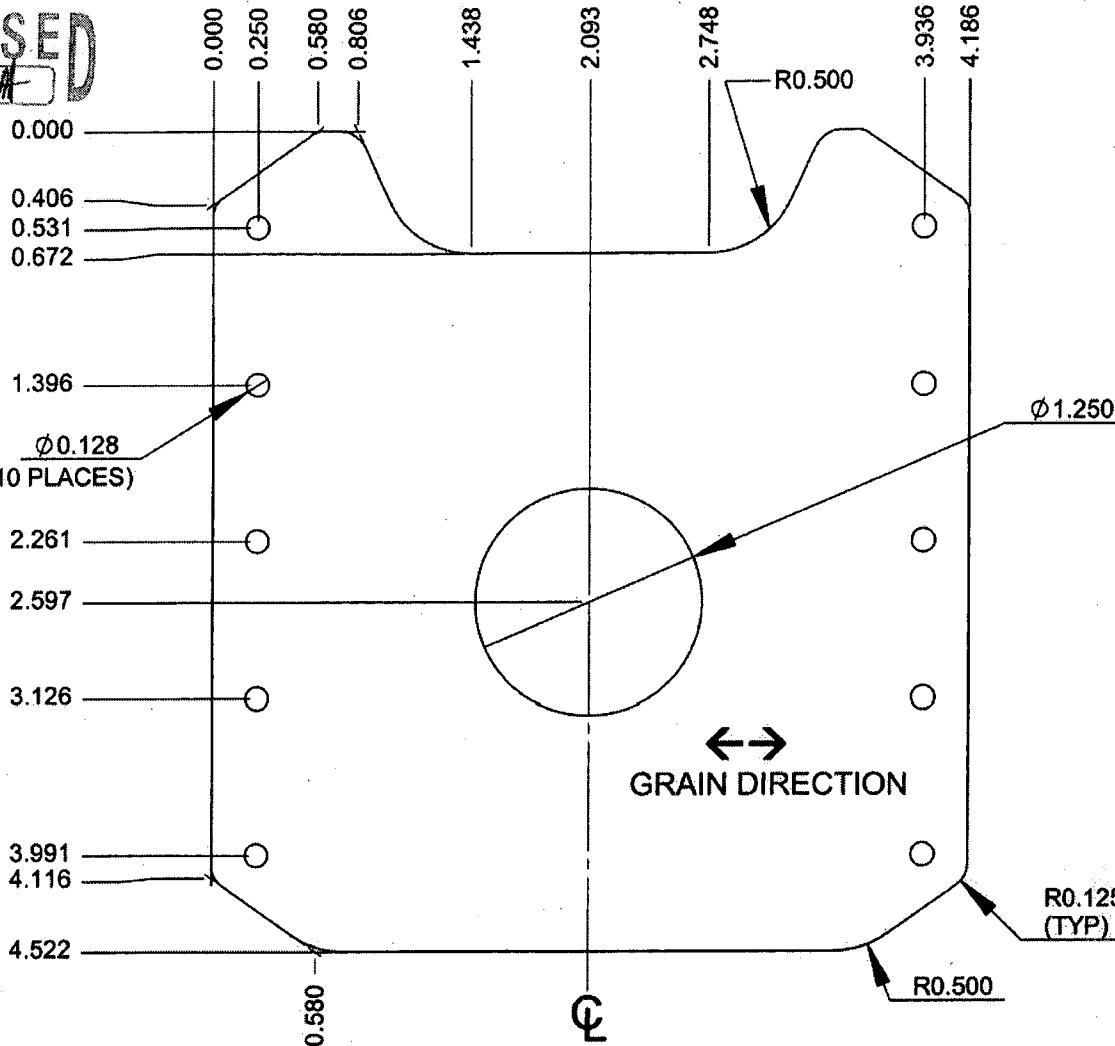
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		D3065	SHEET 5 OF 5

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02.09.2011



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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